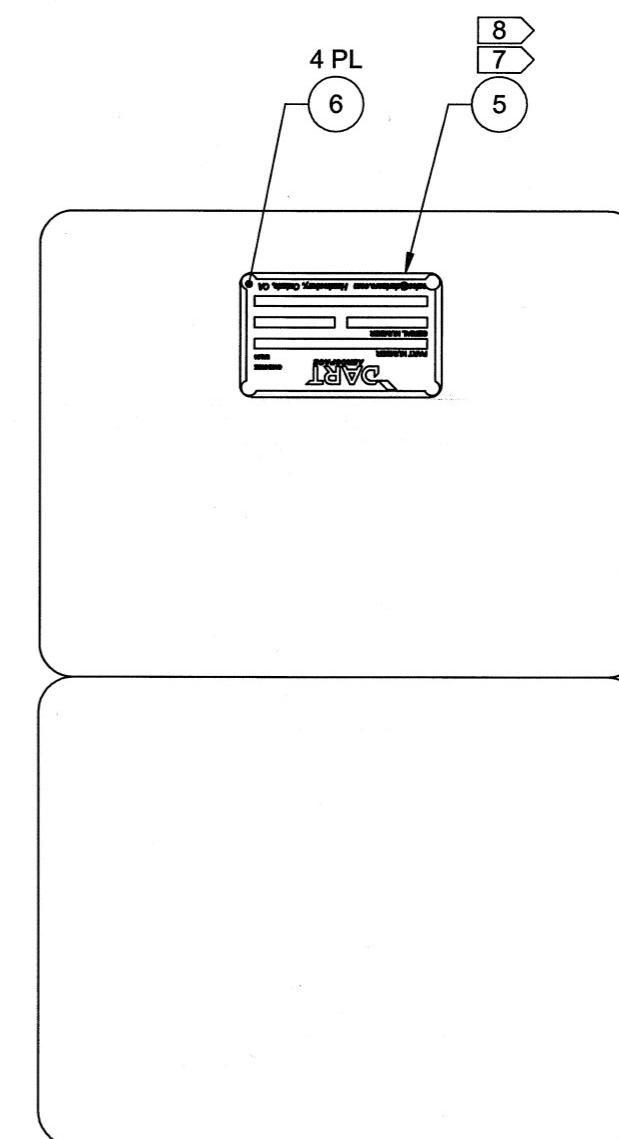
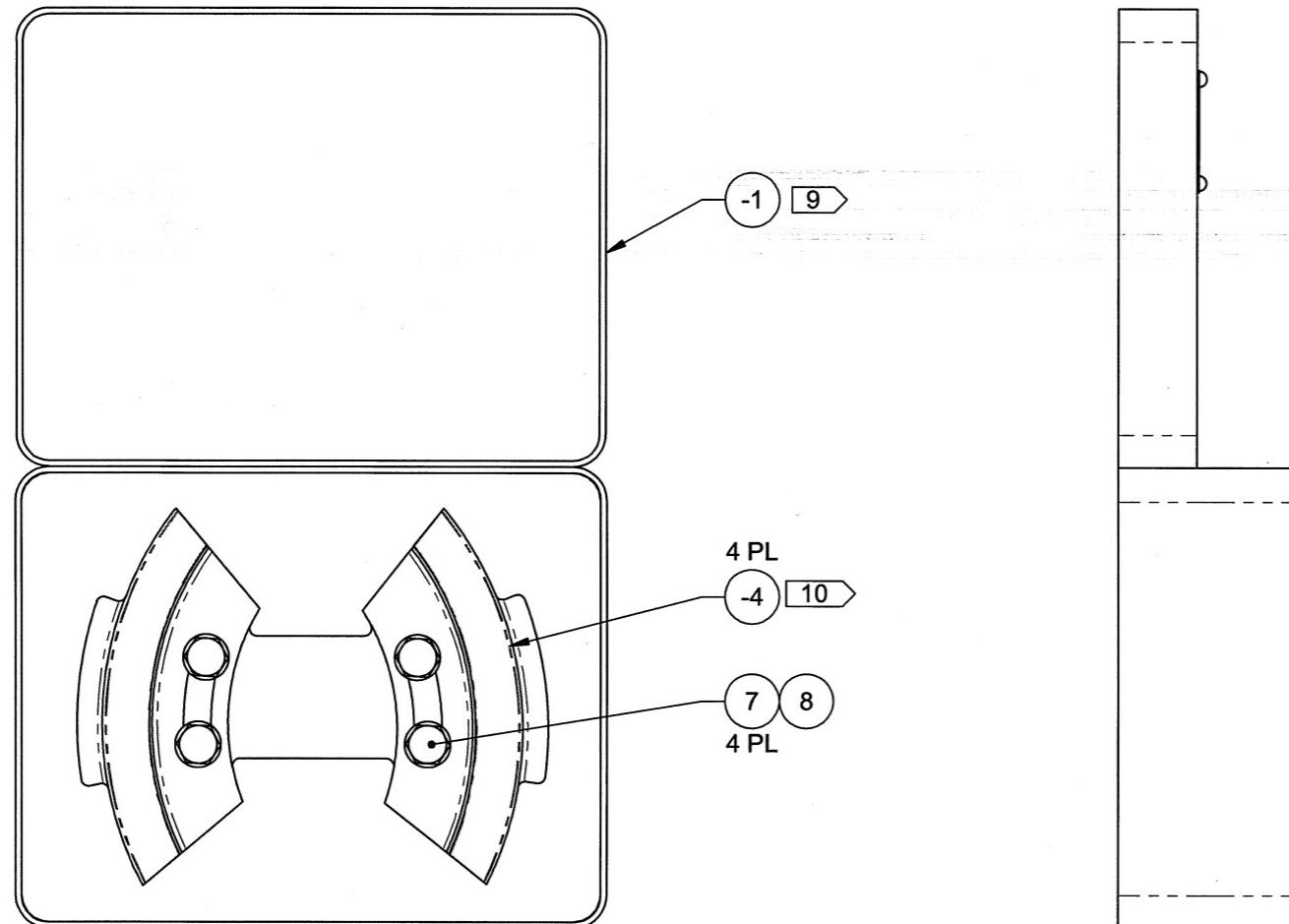


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6220G00131-8G-1	PACKAGING ASSY
-4	4	RBW6220G00131-8G-4	SLIDING RING
5	1	RB41011	DART PLACARD
6	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.
7	4	AN7-10A	BOLT
8	4	NAS1149F0763P	STEEL WASHER 0.453" ID. X 0.750" OD. X 0.063 THK.



NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

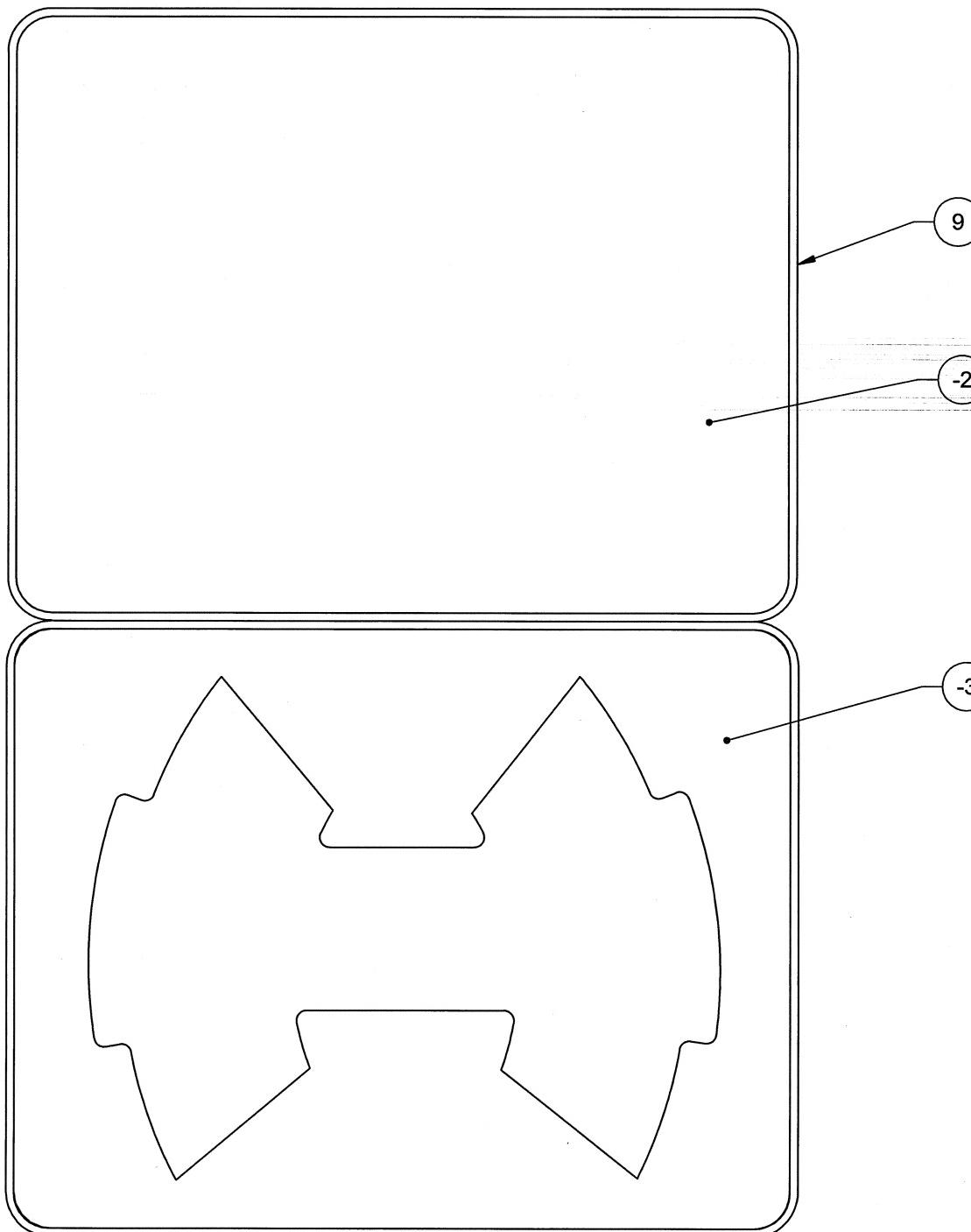
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: N/A
 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINUM POP RIVETS
 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE
 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RBW6220G00131-8G MAIN ROTOR SLIDING RING CENTERING TOOL

A	NEW ISSUE	19-556	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK		
MFG. APPR.	DP		
APPROVED	WY		
DATE 2/4/2019		TOOL PART #	RBW6220G00131-8G
		REV. A	SHEET 1 OF 5
		TITLE	SCALE
		MAIN ROTOR SLIDING RING CENTERING TOOL	NTS
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6220G00131-8G-2	TOP FOAM
-3	1	RBW6220G00131-8G-3	BOTTOM FOAM
9	1	PELICAN #APP-1200-E	PELICAN CASE 1200



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A

RBW6220G00131-8G-1 PACKAGING ASSY

DESIGN DRAWN	VM	DART AEROSPACE LTD
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	PK	TOOL PART # RBW6220G00131-8G
APPROVED	DP	REV. A
	WT	SHEET 2 OF 5
		TITLE
		MAIN ROTOR SLIDING RING CENTERING TOOL
		NTS
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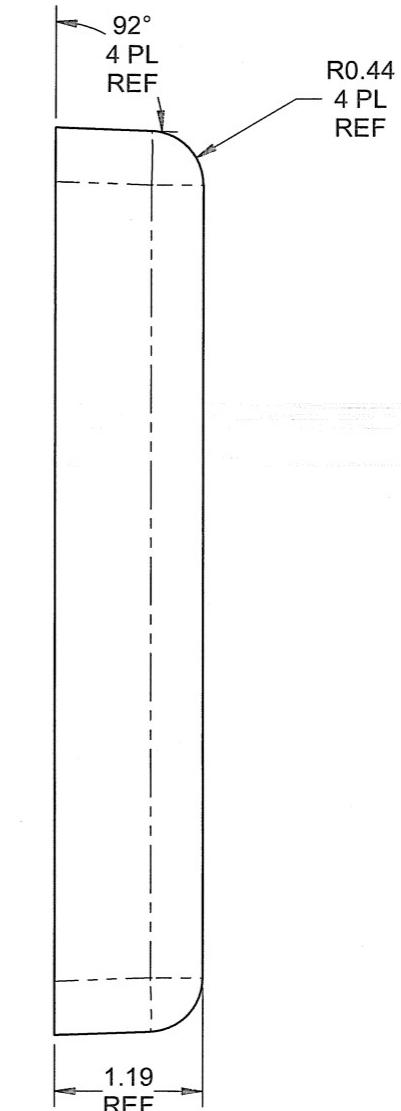
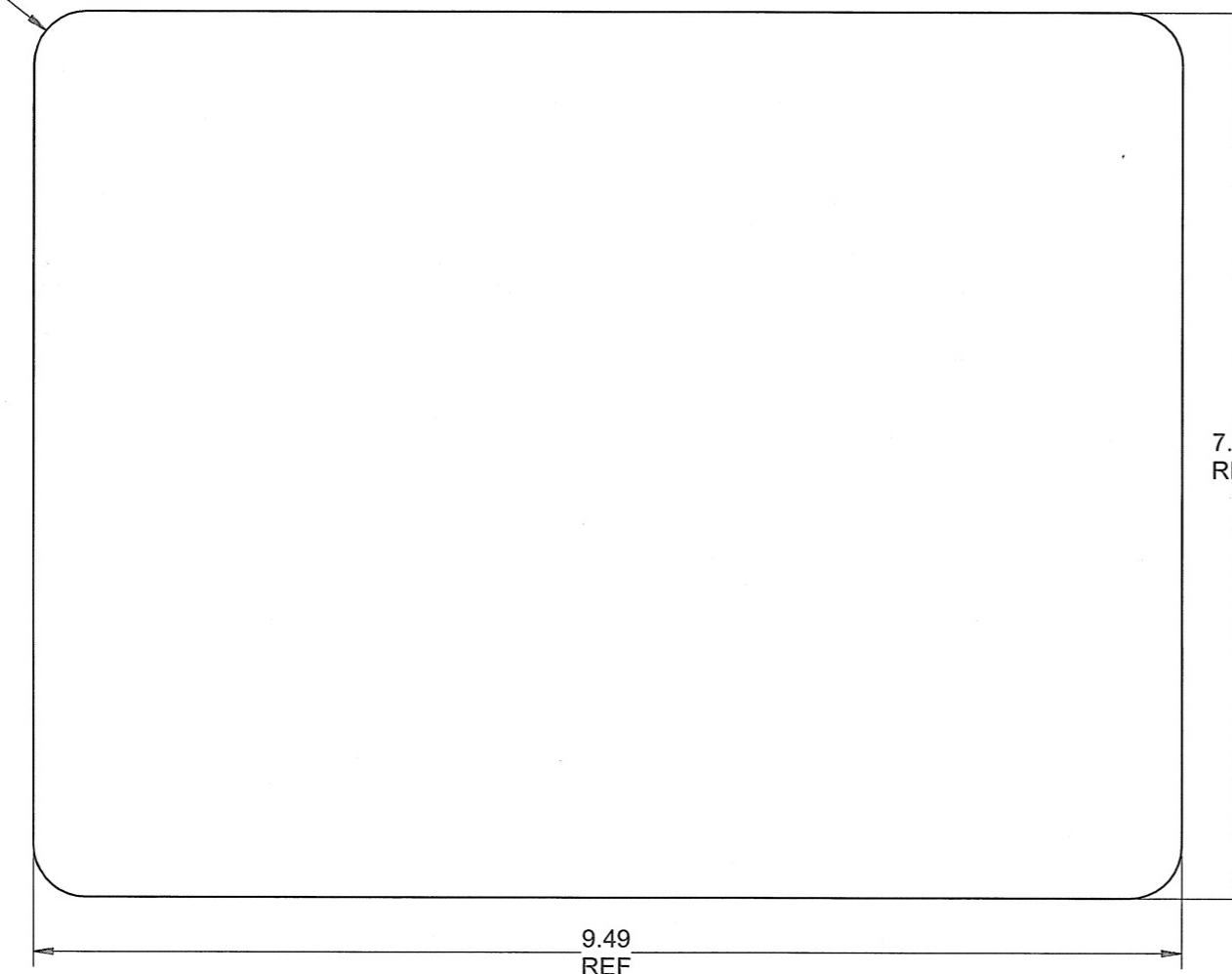
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R0.44
4 PL
REF

RBW6220G00131-8G-2 TOP FOAM

NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220 REF
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBW6220G00131-8G-2 REV A.STEP

DESIGN DRAWN	VM	DART AEROSPACE LTD
CHECKED	PK	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	DP	TOOL PART # RBW6220G00131-8G
APPROVED	WY	REV. A
		SHEET 3 OF 5
		TITLE
		MAIN ROTOR SLIDING RING CENTERING TOOL
		NTS
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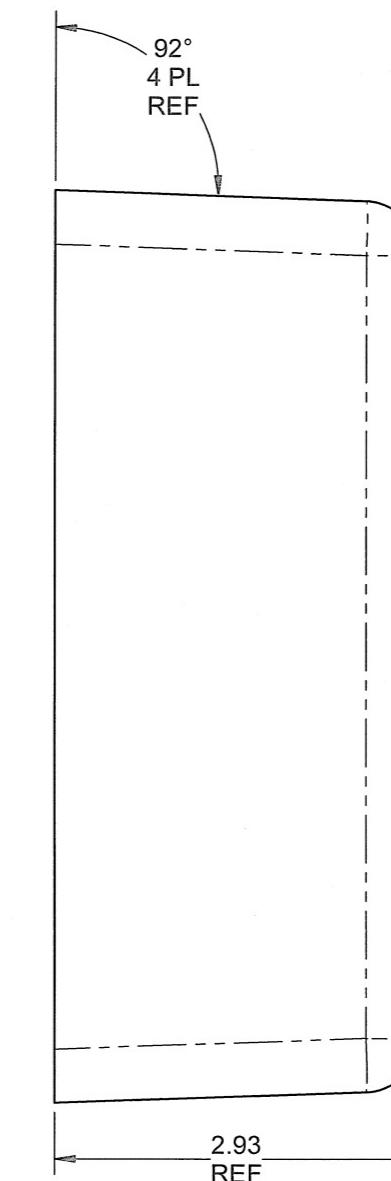
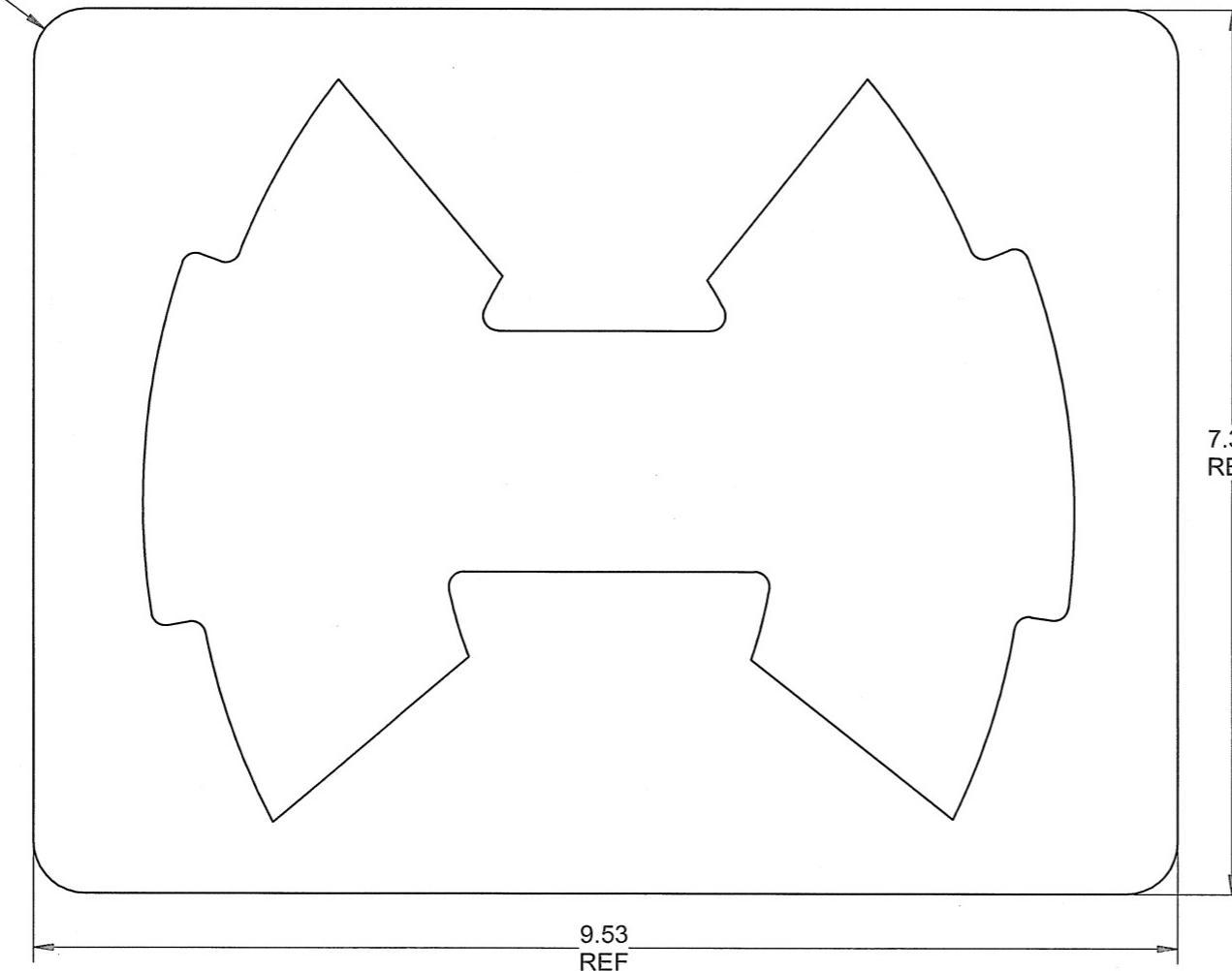
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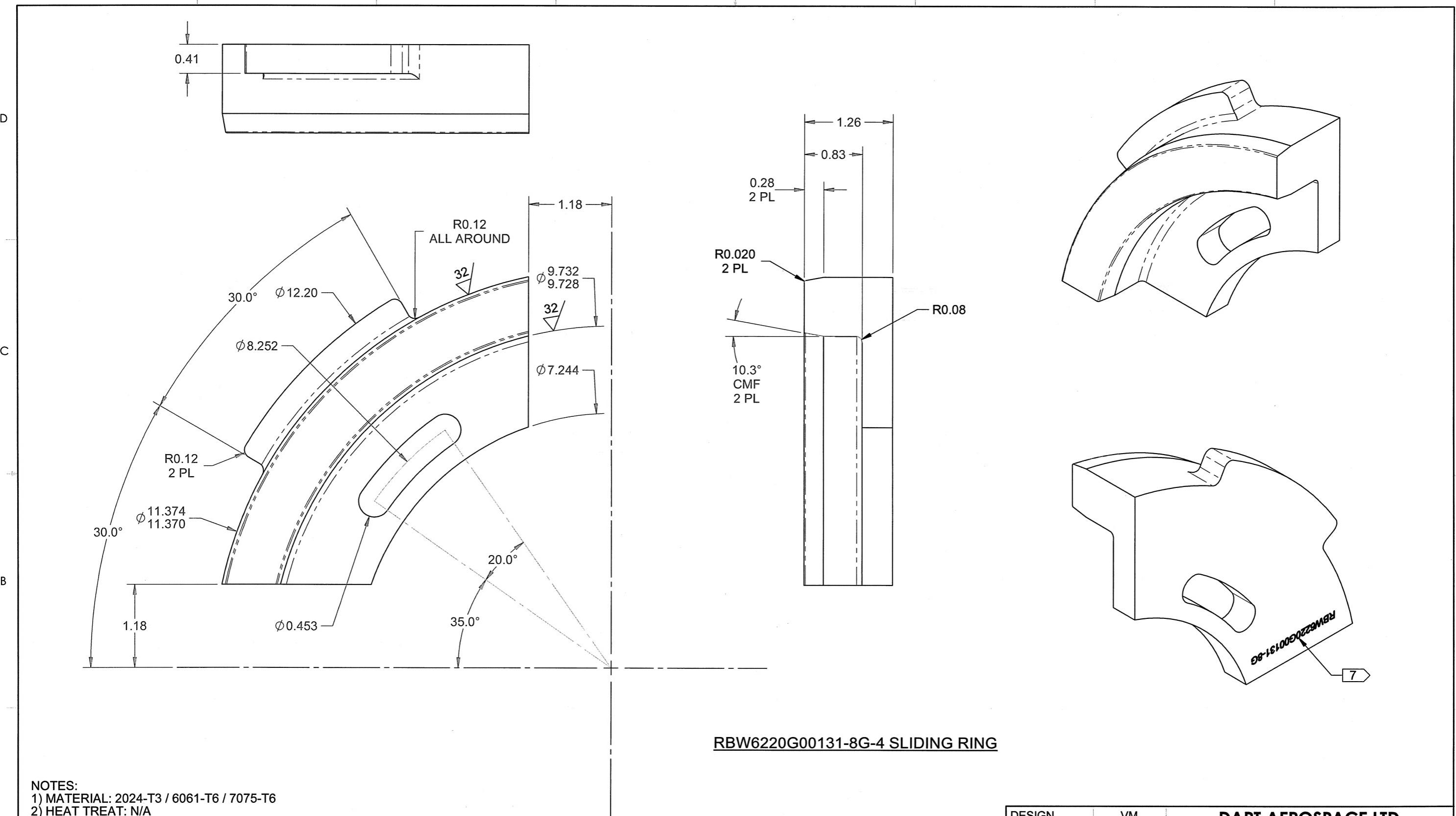
R0.44
4 PL
REF

RBW6220G00131-8G-3 BOTTOM FOAM

NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220 REF
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBW6220G00131-8G-3 REV A.STEP

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	PK	TOOL PART #
MFG. APPR.	DP	REV. A
APPROVED	WY	RBW6220G00131-8G
		SHEET 4 OF 5
		TITLE
		MAIN ROTOR SLIDING RING CENTERING TOOL
		SCALE
		NTS
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RBW6220G00131-8G-4 SLIDING RING

NOTES:

- NOTES:

 - 1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = $^{+/-} 0.1"$ / $^{+/-} 1^\circ$
X.XX = $^{+/-} 0.01"$ / $^{+/-} 0.5^\circ$
X.XXX = $^{+/-} 0.005"$ / $^{+/-} 0.1^\circ$
X.XXXX = $^{+/-} 0.0005"$ / $^{+/-} 0.05^\circ$
 - PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $^{+/-} 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6220G00131-8G	SHEET 5 OF 5
APPROVED	<i>VH</i>	TITLE	SCALE
		MAIN ROTOR SLIDING RING CENTERING TOOL	NTS
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